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D4634-141
Job Sheet 167074-M



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	<i>O.M.L 18-1-23</i>
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	<i>O.M.L 18-1-23</i>
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	<i>O.M.L 18-1-24</i>
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	<i>38</i>
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	<i>O.M.L 18-1-31</i>
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-1 <i>5027046</i>	1	3	0	0
	D4636-5 <i>5004455</i>	1	43	0	0
	D4647-5 <i>5003352</i>	1	2	0	0
	D4664-5 <i>5011418</i>	6	39	0	0
	D4712-1 <i>5008996</i>	1	4	0	0
	D4732-15 <i>5008991</i>	1	2	0	0
	D4732-19 <i>5008993</i>	1	1	0	0
	*D5021-1 <i>50172834</i>	1	<i>5019540</i>	2 <i>5020616</i>	0
	MPNY-750S-9-C F <i>M13042917</i>	1	570	0	0
	MS20426AD3-4 F <i>M134244</i>	4	5,055	0	0
	MS20426AD4-6 F <i>M138621</i>	2	2,797	0	0
	MS21059L08 <i>5019317</i>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____		DISPOSITION Start up Operation 01/24/18 Job No: 167074-M		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																											
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